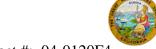
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-016578 Address: 333 Burma Road **Date Inspected:** 30-Aug-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Le Zhi Jiang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 215960 perform Submerged Arc Welding (SAW) Process on weld joint CB3002C-018-001. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

This QA observed ZPMC qualified welding personnel identified as 053609 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3169-004-013. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 053742 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3169-003-019. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

WELDING INSPECTION REPORT

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OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 205386 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3181-2-001-009,010. ZPMC Quality Control Personnel (QC) identified as Mr. Guo Pan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 217185 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3181-2-001-003,004. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

OBG #BAY 8

This QA inspector observed that ZPMC Magnetic particle Testing (MT) personnel perform MT of Bike path various weld joints. See attached pictures.

OBG # CROSS BEAM CB11 (BLAST SHOP)

This Quality Assurance (QA) Inspector performed random visual inspection of OBG Cross beam CB11 outside surfaces after grit blasting. Areas that marked for repair were recorded for future repair. And some areas requiring additional grinding were marked by QA Inspector and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

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your project.

Inspected By: Sukanthan, Dhanasingh Quality Assurance Inspector

Reviewed By: Hall,Steven QA Reviewer